

Work Order ID 56132



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February 10, 2010 2:52:15 PM

| | | | | | | | |
|----------------|------------------------|---------------|------------|---------------|-------|-------|--|
| Item ID: | D205-634-041 | Accept | | Setup | Start | | |
| Revision ID: | | | | | | | |
| Item Name: | Replacement Skidtube | | | | Stop | | |
| Start Date: | 2/10/10 | Start Qty: | 1.00 | Cust Item ID: | | | |
| Required Date: | 2/26/10 | Req'd Qty: | 1.00 | Customer: | | | |
| Reference: | | | | | | | |
| Approvals: | Process Plan: <i>M</i> | Date: 10-2-10 | Tooling: | Date: | Run | Start | |
| | QC: | Date: | SPC (Y/N): | Date: | | Stop | |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr | | | | | | | | |
|----------|--------------|--|--|--|--|--|--|--|--|
| D2580 | Rev D | | | | | | | | |

100 0.00

 DOCUMENT CONTROL

DC Memo 0.00
 Document Control Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

N/A HJ

110 0.00

 BENDING MACHINE - SKIDTUBES

CNC Bend 1 Memo 0.00
 CNC Delta 100 Bender 1-Bend as per program D2580.C on CNC Bender and Folio FT009
 2-Cut tubes as per Dwg. D2580

> DD

10-2-18

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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| Approvals: | Process Plan: | Date: | Tooling: | Date: | Run | Start | |
| | QC: | Date: | SPC (Y/N): | Date: | | Stop | |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| 120 | | 0.00 | | | | | | | |
| Skidtubes | Memo | 0.00 | | | | | | | |
| Skidtubes | 1- Deburr ends | | | | | | | | |
| | 2- C'sink holes as per dwg without cutting fluid | | | | | | | | |
| | 3- Prepare tube for welding, remove alodine as required. | | | | | | | | |
| | 4- Scribe batch number insied aft end of tube. | | | | | | | | |
| 130 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

(X) do nb 10-02-22

x / DE 10/02/22

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 2/10/10 Start Qty: 1.00



Cust Item ID:

Required Date: 2/26/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



Skidtubes

Memo

0.00

Skidtubes

1-Weld step D2576 as per Dwg. D2580 and QSI 004
A/R□□□ Aluminum Rod

M113207

86 10/02/23

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill
A/R□□□ Aluminum Rod

M113207

86 02/02/23

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64",
adjust stopper not to hit web.Deburr5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580.
Deburr holes

6-Drill pilot holes for aft cap using DT 8215Open holes to 0.208". Deburr

7-Drill pilot holes for Tow ring using DT8091, open to .640"and Deburr

10-2-23

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Item ID: D205-634-041

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Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 2/10/10 Start Qty: 1.00



Cust Item ID:

Required Date: 2/26/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberReject
NumberInsp.
Stamp

150

QC10- Inspect visual per QSI004- ground welds

0.00

S.02/24

0.00



QC

Quality Control

160

QC5- Inspect part completeness to step on W/O

0.00

S.02/24

0.00



QC

Quality Control

170

Pressure Wash per QSI005 4.3

0.00

=>M 10/03/09

0.00

tRcalodinc AS per PAR09-043
HandFinish
Memo

Hand Finishing

(X)

(X) Ø

| W/O: | | WORK ORDER CHANGES | | | | | |
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| Item Name: | Replacement Skidtube | | | | | | |
| Start Date: | 2/10/10 | Start Qty: | 1.00 | | Cust Item ID: | | |
| Required Date: | 2/26/10 | Req'd Qty: | 1.00 | | Customer: | | |
| Reference: | | | | | | | |
| Approvals: | Process Plan: | Date: | Tooling: | Date: | Run | Start | |
| | QC: | Date: | SPC (Y/N): | Date: | | Stop | |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|---------------------------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
| 180 Powdercoat | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum | 0.00 | M113170 | => Y1 | 10/63/09 | X | O | P | |
| Powder Coating | Memo START TIME: OVEN TEMPERATURE: FINISH TIME: | 0.00 11:30 AM 320°F 12:00 PM | | | | | | | |
| 190 QC | QC3- Inspect Part Finish | 0.00 | | BL 10-3-10 | | D. | .d. | | |
| Quality Control | Memo | 0.00 | | | | | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 2/10/10 Start Qty: 1.00



Cust Item ID:

Required Date: 2/26/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200



HandFinish

Hand Finishing

Memo

0.00

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R Sikaflex-291

Sikaflex expire date:

112345
10/08

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291

Sikaflex expire date:

112345
10/085-Wing Walk as per Dwg D2580 and QSI 005 4.4
Batch: 113462

7
BL 10-3-10. Ø

| W/O: | | WORK ORDER CHANGES | | | | | |
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| Revision ID: | | | | | | | | | | |
| Item Name: | Replacement Skidtube | | | | | | | Stop | | |
| Start Date: | 2/10/10 | Start Qty: 1.00 | | | | Cust Item ID: | | | | |
| Required Date: | 2/26/10 | Req'd Qty: 1.00 | | | | Customer: | | | | |
| Reference: | | | | | | | | | | |
| Approvals: | Process Plan: | Date: | Tooling: | Date: | | Run | Start | | | |
| | QC: | Date: | SPC (Y/N): | Date: | | | Stop | | | |
| Sequence ID/ Work Center ID | Operation Description | | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
| 210 | QC5- Inspect part completeness to step on W/O | Memo | 0.00 | 8 10/01/11 | | | | | | |
| QC | | | | | | | 40 | | | |
| Quality Control | | Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024 | | | | | | | | |
| 220 | Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | | |
| Packaging | | Identify and pack for shipping as per PPPD205-634-041 | | | | | | | | |
| | | Location: PPP Rev: 56706 | | | | | | | | |
| 230 | QC21- Final Inspection - Work Order Release | Memo | 0.00 | | | | | | | |
| QC | | | | | | | | | | |
| Quality Control | | | | | | | | | | |

10/03/11 CJ

10/03/11 DJ

MF 10-3-11

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

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Work Order ID: 56132



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ

Start Date: 2/10/10

Required Date: 2/26/10

IPP Rev:O 06.02.28 Added paperwork EC

Start Qty: 1.00

IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Required Qty: 1.00

| Component Item ID/ D2580-1 | Replacement Barcode | Mfg/ Manufactured | Bin No | Primary Location | Last Route | Unit of Each | Qty on 5.0000 | Remaining 1.0000 | Qty Barcode | Date | Status |
|-------------------------------|------------------------|----------------------|-----------|---------------------|---------------|-----------------|------------------|---------------------|----------------|------|--------|
| 205 Skidtube bent detail | | | | | 110 | | | | | | |

Warehouse Location

Main Warehouse

B 56123

1 M10/2/18

LG

5

54541

2

54697

2

54721

1

D2576-3



Step (machining detail)

Manufactured

No

140

Each

141.0000 1.0000

Warehouse Location

Main Warehouse

ST

141

46661

94

52215

47

1 8E 10/02/03

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Work Order ID: 56132



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 2/10/10

Required Date: 2/26/10

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ

Start Qty: 1.00

IPP Rev. O 06.02.28 Added paperwork EC

Required Qty: 1.00

IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

| Component Item ID/ D2579 | Replacement | Mfg/ Manufactured | Bin No | Primary Last | Route 140 | Unit of Each | Qty on 147.0000 | Remaining 20.0000 | Qty | Date | Status |
|-----------------------------|-------------|----------------------|-----------|-----------------|--------------|-----------------|--------------------|----------------------|-----|------|--------|
| Crossbolt Spacer | | | | | | | | | | | |

| Warehouse Location | Loc Qty | Loc Code |
|-----------------------|---------|----------|
| Main Warehouse | | |
| LG | 25 | |
| 51525 | 4 | |
| 53780 | 3 | |
| 54543 | 18 | |
| Main Warehouse | | |
| ST | 122 | |
| 43988 | 4 | |
| 46434 | 4 | |
| 46956 | 2 | |
| 47797 | 9 | |
| 48272 | 2 | |
| 51314 | 71 | |
| 51315 | 30 | |

25645

x20

BC 10/02/23

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
IPP Rev. O 06.02.28 Added paperwork EC
IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Date: 2/10/10

Required Date: 2/26/10

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ D2855 | Replacement | Mfg/ Manufactured | Bin No | Primary Last | Route 200 | Unit of Each | Qty on 151.0000 | Remaining 1.0000 | Qty | Date | Status |
|-----------------------------|-------------|----------------------|-----------|-----------------|--------------|-----------------|--------------------|---------------------|-----|------|--------|
| Cap | | | | | | | | | | | |

Warehouse Loc Qty Loc Code

Location

Main Warehouse

| | |
|-------|-----|
| ST026 | 151 |
| 50513 | 1 |
| 50770 | 1 |
| 51539 | 39 |
| 53791 | 110 |

AN3-5A



| | | | | | |
|-----------|----|-----|------|-----------|--------|
| Purchased | No | 200 | Each | 1,773.000 | 2.0000 |
|-----------|----|-----|------|-----------|--------|



Warehouse Loc Qty Loc Code

Location

Main Warehouse

| | |
|--------|------|
| ST | 1773 |
| 100188 | 188 |
| 105057 | 1585 |

Bolt

1 BL 10-3-10

2 BL 10-3-10 .

| W/O: | | WORK ORDER CHANGES | | | | | |
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Parent Item Name: Replacement Skidtube

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Required Date: 2/26/10

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ

Start Qty: 1.00

IPP Rev. O 06.02.28 Added paperwork EC

Required Qty: 1.00

IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

| Component Item ID/ AN960JD10L | Replacement Washer | Mfg/ Purchased | Bin No | Primary | Last | Route 200 | Unit of Each | Qty on 3,459.000 | Remaining 2.0000 | Qty | Date | Status |
|----------------------------------|-----------------------|-------------------|-----------|---------|------|--------------|-----------------|---------------------|---------------------|-----|------|--------|
| | | | | | | | | | | | | |

Washer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

| | |
|---------|------|
| ST | 3459 |
| 101291 | 16 |
| 105793 | 49 |
| 110985✓ | 3394 |

ALS7-1032-130



Purchased

No

200 Each 986.0000 50.0000

2. BL 10-3-10

Insert

Warehouse Loc Qty Loc Code

Location

Main Warehouse

| | |
|------------|-----|
| ST 110511. | 986 |
| 108606 | 52 |
| 111529 | 130 |
| 111779 | 34 |
| 112772 | 11 |
| 113238 | 759 |

ALS4-1032-130.

50. BL 10-3-10 ,

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

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Page 5

Work Order ID: 56132



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 2/10/10

Required Date: 2/26/10

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ

Start Qty: 1.00

IPP Rev. O 06.02.28 Added paperwork EC

Required Qty: 1.00

IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

| Component Item ID/ AN3C4A | Replacement | Mfg/ Purchased | Bin No | Primary | Last | Route 200 | Unit of Each | Qty on 1,263.000 | Remaining 50.0000 | Qty | Date | Status |
|------------------------------|-------------|-------------------|-----------|---------|------|--------------|-----------------|---------------------|----------------------|-----|------|--------|
| BOLT | | | | | | | | | | | | |

Warehouse

Location

Main Warehouse

| | | |
|--------|--------|------|
| ST | 114103 | 1263 |
| 112314 | | 13 |
| 112720 | | 12 |
| 112724 | | 3 |
| 112829 | | 1 |
| 112991 | | 2 |
| 113121 | | 64 |
| 113226 | | 344 |
| 113422 | | 124 |
| 113644 | | 500 |
| 113749 | | 200 |

50. BL 10-3-10.

AN960C10L



Purchased

No

200

Each

388.0000 50.0000



washer

Warehouse

Location

OFFSHORE

| | | |
|--------|---------|-----|
| FG | 113737. | 100 |
| 103585 | | 100 |

43. BL 10-3-10

Main Warehouse

| | |
|--------|-----|
| ST | 288 |
| 112116 | 128 |
| 112612 | 160 |

113691

Shop Packet Print

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7. BL 10-3-10

Page 5

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 56132



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 2/10/10

Required Date: 2/26/10

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ

Start Qty: 1.00

IPP Rev. O 06.02.28 Added paperwork EC

Required Qty: 1.00

IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

| Component Item ID/ D3566-13 | Replacement | Mfg/ Manufactured | Bin No | Primary | Last | Route 200 | Unit of Each | Qty on 83.0000 | Remaining 1.0000 | Qty | Date | Status |
|--------------------------------|-------------|----------------------|-----------|---------|------|--------------|-----------------|-------------------|---------------------|-----|------|--------|
| | | | | | | | | | | | | |



Gasket

D3566-5



Manufactured

No

| Warehouse | Loc Qty | Loc Code |
|-----------|---------|----------|
|-----------|---------|----------|

Location

Main Warehouse

| | |
|-------|----|
| FP | 81 |
| 53461 | 81 |

Main Warehouse

| | |
|-------|---|
| ST | 2 |
| 45717 | 1 |
| 50265 | 1 |

1 BK10-3-10

| | | | |
|-----|------|---------|--------|
| 200 | Each | 34.0000 | 1.0000 |
|-----|------|---------|--------|



Gasket

| Warehouse | Loc Qty | Loc Code |
|-----------|---------|----------|
|-----------|---------|----------|

Location

Main Warehouse

| | |
|-------|----|
| FP19 | 30 |
| 55026 | 18 |
| 55335 | 12 |

Main Warehouse

| | |
|-------|---|
| ST | 4 |
| 36113 | 1 |
| 46186 | 1 |
| 47318 | 1 |
| 51260 | 1 |

1 BK10-3-10

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

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Page 7

Work Order ID: 56132



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 2/10/10

Required Date: 2/26/10

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ
 IPP Rev: O 06.02.28 Added paperwork EC
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ D3566-1 | Replacement | Mfg/ Manufactured | Bin No | Primary Last | Route 200 | Unit of Each | Qty on 39.0000 | Remaining 2.0000 | Qty | Date | Status |
|-------------------------------|-------------|----------------------|-----------|-----------------|--------------|-----------------|-------------------|---------------------|-----|------|--------|
| | | | | | | | | | | | |

Gasket

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
|------------------|----------------|-----------------|

Location

Main Warehouse

| | | |
|----------|----|---------------|
| FP 56532 | 34 | 1 BL 10-3-10. |
| 52512 | 3 | _____ |
| 54480 | 1 | _____ |
| 55011 | 3 | _____ |
| 55320 ✓ | 27 | _____ |

Main Warehouse

| | | |
|-------|---|-------|
| ST | 5 | _____ |
| 46349 | 1 | _____ |
| 51218 | 1 | _____ |
| 51259 | 3 | _____ |

D3564-11



Manufactured

No

200 Each 5.0000 1.0000

| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
|------------------|----------------|-----------------|

Location

Main Warehouse

| | | |
|------------|---|---------------|
| FP19 55332 | 3 | 1 BL 10-3-10. |
| 52125 | 3 | _____ |

Main Warehouse

| | | |
|-------|---|-------|
| ST | 2 | _____ |
| 45823 | 1 | _____ |
| 50112 | 1 | _____ |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 56132



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 2/10/10

Required Date: 2/26/10

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ

Start Qty: 1.00

IPP Rev. O 06.02.28 Added paperwork EC

Required Qty: 1.00

IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

| Component Item ID/ D3564-13 | Replacement | Mfg/ Manufactured | Bin No. | Primary Last | Route 200 | Unit of Each | Qty on 23.0000 | Remaining 1.0000 | Qty | Date | Status |
|--------------------------------|-----------------|----------------------|------------|-----------------|--------------|-----------------|-------------------|---------------------|---------|------|--------|
| Wearshoe | | | | | | | | | | | |

| <u>Warehouse</u> <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-------------------------------------|----------------|-----------------|
|-------------------------------------|----------------|-----------------|

Main Warehouse

FP17 *56285*

11

51611

11

1 *BK10-3-10.*

Main Warehouse

ST

12

45409

2

46495

10

D3564-9



Manufactured No

200 Each 14.0000 1.0000

| <u>Warehouse</u> <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-------------------------------------|----------------|-----------------|
|-------------------------------------|----------------|-----------------|

Main Warehouse

FP19

12

55025

12

1 *BK10-3-10.*

Main Warehouse

ST

2

44659

1

45825

1

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

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Page 9

Work Order ID: 56132



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 2/10/10

Required Date: 2/26/10

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ

Start Qty: 1.00

IPP Rev. O 06.02.28 Added paperwork EC

Required Qty: 1.00

IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

| Component Item ID/ D3564-5 | Replacement | Mfg/ Manufactured | Bin No | Primary | Last | Route 200 | Unit of Each | Qty on 44.0000 | Remaining 1.0000 | Qty | Date | Status |
|-------------------------------|-------------|----------------------|-----------|---------|------|--------------|-----------------|-------------------|---------------------|-----|------|--------|
| Wearshoe | | | | | | | | | | | | |

| Warehouse <u>Location</u> | Loc Qty | Loc Code |
|------------------------------|---------|----------|
| OFFSHORE | | |
| FG | 2 | |
| 34806 | 2 | |
| Main Warehouse | | |
| FP19 | 40 | |
| 51925 | 1 | |
| 54772 | 13 | |
| 55024 | 12 | |
| 55333 | 14 | |
| Main Warehouse | | |
| ST | 2 | |
| 45824 | 1 | |
| 47433 | 1 | |

1 BK 10-3-10.

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

February 10, 2010 2:52:20 PM

Page 10

Work Order ID: 56132



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 2/10/10

Required Date: 2/26/10

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ

Start Qty: 1.00

IPP Rev. O 06.02.28 Added paperwork EC

Required Qty: 1.00

IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

| Component Item ID/ D2594-3 | Replacement | Mfg/ Manufactured | Bin No | Primary | Last | Route 200 | Unit of Each | Qty on 668.0000 | Remaining 16.0000 | Qty | Date | Status |
|-------------------------------|-------------|----------------------|-----------|---------|------|--------------|-----------------|--------------------|----------------------|-----|------|--------|
| | | | | | | | | | | | | |

O-Ring, 205 Skidtube

| Warehouse | Loc Qty | Loc Code |
|-----------------|---------|----------|
| <u>Location</u> | | |
| Main Warehouse | | |
| FP | 527 | |
| 51613 ✓ | 27 | |
| 55546 ✓ | 500 | |
| Main Warehouse | | |
| ST | 141 | |
| 52562 | 141 | |

16-BK 10-3-10.

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 56132



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ

Start Date: 2/10/10

Required Date: 2/26/10

IPP Rev. O 06.02.28 Added paperwork EC

Start Qty: 1.00

Required Qty: 1.00

IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

| Component Item ID/ D2594-1 | Replacement | Mfg/ Manufactured | Bin No | Primary Last | Route 200 | Unit of Each | Qty on 705.0000 | Remaining 16.0000 | Qty | Date | Status |
|-------------------------------|-------------|----------------------|-----------|-----------------|--------------|-----------------|--------------------|----------------------|-----|------|--------|
| | | | | | | | | | | | |

Plug, 205 Skidtube

| Warehouse <u>Location</u> | Loc Qty | Loc Code | | | | | | |
|------------------------------|---------|----------|--|--|--|--|--|--|
| | | | | | | | | |
| Main Warehouse | | | | | | | | |
| FP | 577 | | | | | | | |
| 54008 | 1 | | | | | | | |
| 54643 | 15 | | | | | | | |
| 55002 ✓ | 561 | | | | | | | |
| Main Warehouse | | | | | | | | |
| ST | 128 | | | | | | | |
| 42221 | 16 | | | | | | | |
| 42807 | 92 | | | | | | | |
| 43884 | 3 | | | | | | | |
| 46435 | 2 | | | | | | | |
| 51527 | 9 | | | | | | | |
| 51757 | 6 | | | | | | | |

16, fl 10-3-10.

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

DART

| | | | |
|-------------------------------|--------------------------------|--|------------------------|
| DESIGN <i>[Signature]</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2580 | REV. D SHEET 1 OF 3 |
| DATE 07.02.27 | | TITLE 205 SKIDTUBE ASSEMBLY | SCALE NTS |
| A | 96.09.16 | NEW ISSUE | |
| B | 96.12.02 | AS MANUFACTURED | |
| C | 98.08.26 | REDRAWN, INCLUDED DEO 9094/9097 | |
| D | 07.02.27 | CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183 | |

RELEASED
07.06.28

| QTY -041 | QTY -045 | Part Number | Description |
|-------------|-------------|---|-------------------|
| X | | D2580-041 | SKIDTUBE ASSEMBLY |
| | X | D2580-045 | SKIDTUBE ASSEMBLY |
| 1 | 1 | D2500-1-190 | EXTRUSION |
| 1 | 1 | D2576-3 | STEP |
| 20 | 24 | D2579 | CROSS BOLT SPACER |
| 16 | 16 | D2594-1 | PLUG |
| 16 | 16 | D2594-3 | O-RING |
| 1 | 1 | D2596 | 205 WEB |
| 1 | 1 | D2855 | AFT CAP |
| 1 | 1 | D3564-5 | WEARSHOE |
| 1 | 1 | D3564-9 | WEARSHOE |
| 1 | 1 | D3564-11 | WEARSHOE |
| 1 | 1 | D3564-13 | WEARSHOE |
| 2 | 2 | D3566-1 | GASKET |
| 1 | 1 | D3566-5 | GASKET |
| 1 | 1 | D3566-13 | GASKET |
| 50 | 50 | ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AEKS-1032-130 | INSERT |
| 50 | 50 | AN3C4A | BOLT |
| 2 | 2 | AN3-5A | BOLT |
| 50 | 50 | AN960C10L | WASHER |
| 2 | 2 | AN960JD10L | WASHER |

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 56132

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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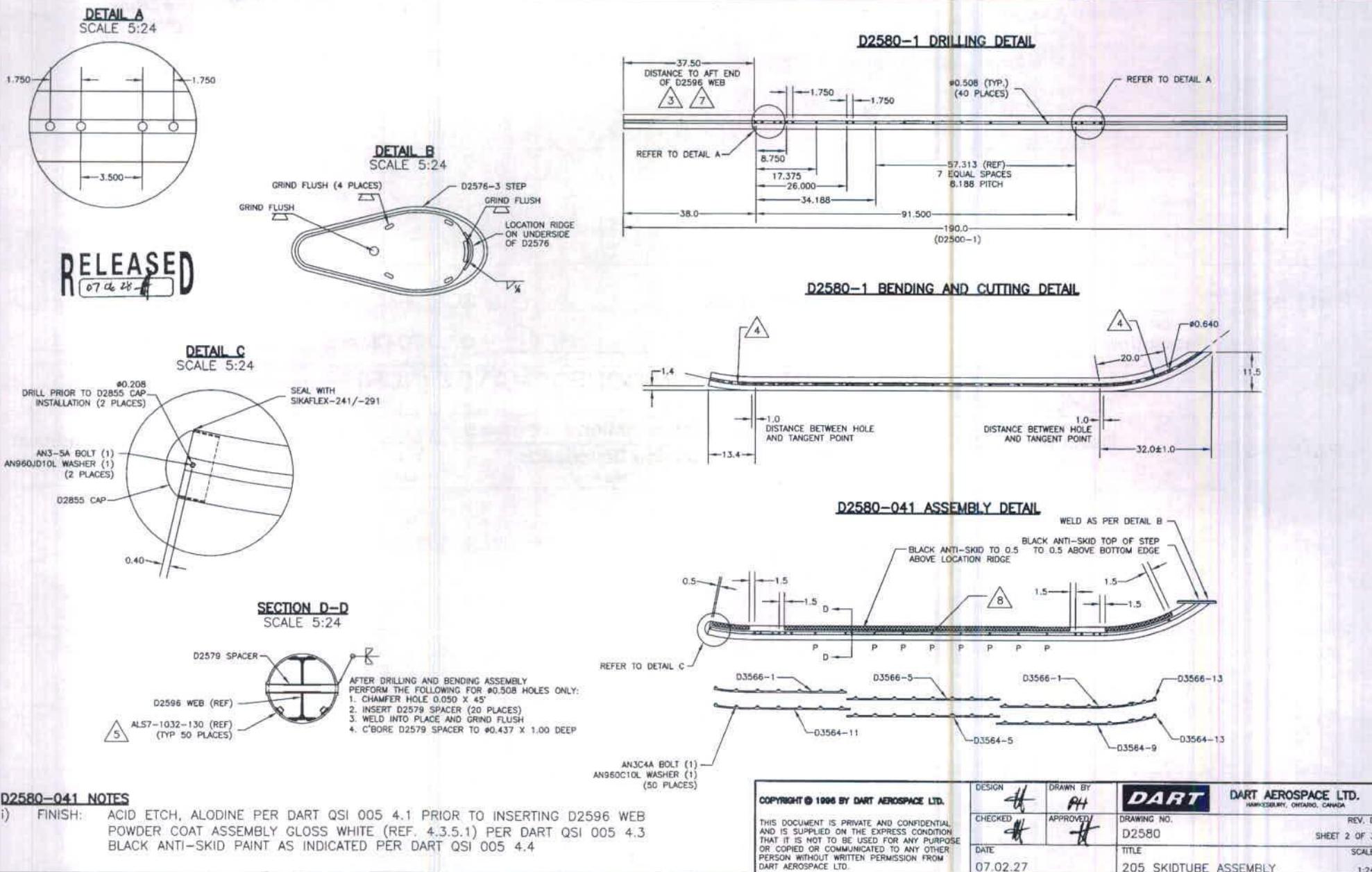
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

W10 56132



| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

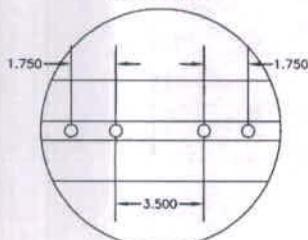
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

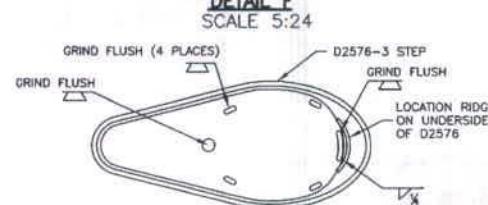
W056132

DETAIL E
SCALE 5:24

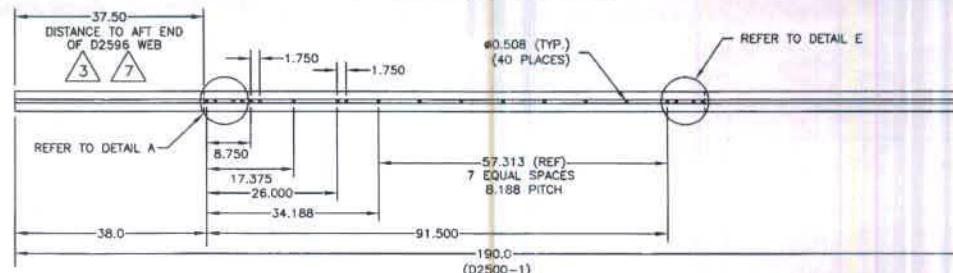


RELEASED
07-06-28

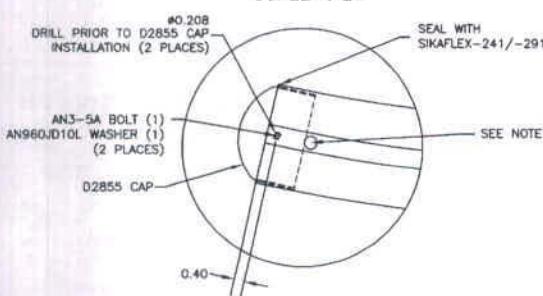
DETAIL F
SCALE 5:24



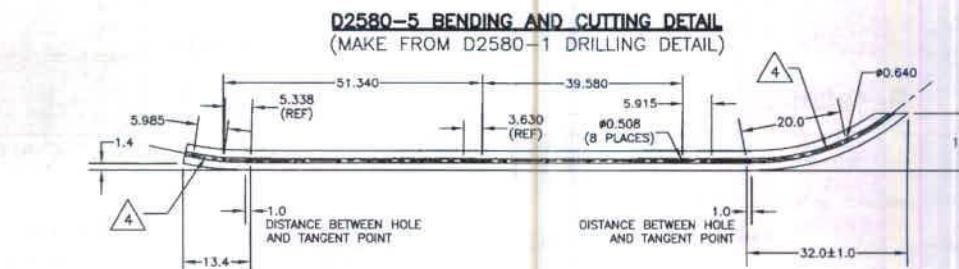
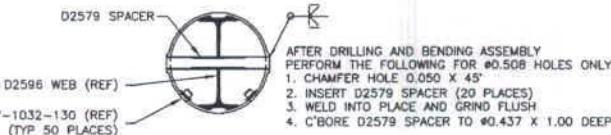
D2580-1 DRILLING DETAIL



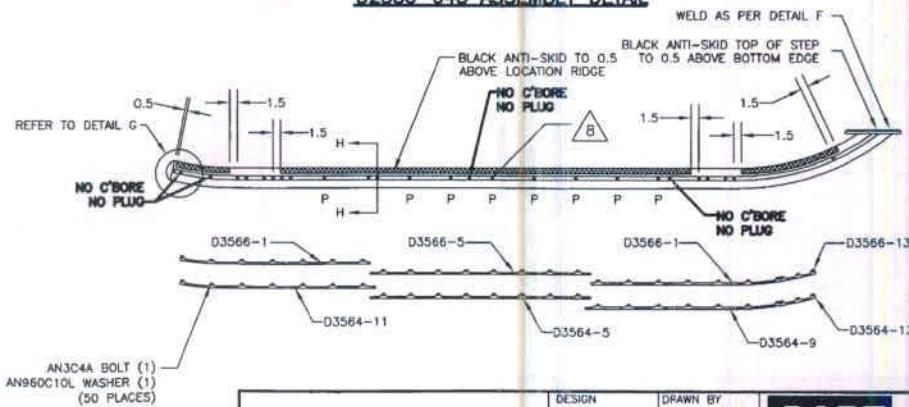
DETAIL G
SCALE 5:24



SECTION H-H
SCALE 5:24



D2580-045 ASSEMBLY DETAIL



D2580-045 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE
WITH THE SPACER AT THIS LOCATION

AN304A BOLT (1)
AN960C10L WASHER (1)
(50 PLACES)

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DART AEROSPACE LTD.

| DESIGN | DRAWN BY | DART | DART AEROSPACE LTD. HANNESBURY, ONTARIO, CANADA |
|------------------|--------------------------------|---------------|--|
| RH | RH | | |
| CHECKED | APPROVED | | REV. D D2580 SHEET 3 OF 3 |
| DATE 07.02.27 | TITLE 205 SKIDTUBE ASSEMBLY | SCALE 1:24 | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

NO. 226

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 56134
Part number: D205 634.041
Description: 205 skid tube
Welding Process: Tig[] Mig[]
Base material: Aluminum
Current: AC[] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[] fail[]
Penetration: pass[] fail[]

UNACCEPTABLE

Cracks: pass[] fail[]
Undercut: pass[] fail[]
Pin holes: pass[] fail[]
Overlap (cold lap) pass[] fail[]
Porosity (surface): pass[] fail[]
Coloration: pass[] fail[]

Qualifier B.D. Date of Test Coupon 10-02-23

Welder Barclay Elliott Date of Test Coupon 10-02-23

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

